

Date: Tuesday, 12/20/2005 3:40:13 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 204 SKIDTUBE "I" BEAM		
Job Number	: 25336		Part Number	: D2597		
Estimate Number	: 10996		Drawing Number	: D2597 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/20/2005 S.O. No. : N/A		Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/15/2006		
Previous Run	: N/A		Qty:	2 Um: Each		
Written By	: See Comment below					
Checked & Approved By	: See Comment below					
Comment	: Est: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n - 'I' Beam Web 4"	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion ③ 19074 A.M 05-12-29 ②			
2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1			
			
Comment: LANDING GEAR RESOURCE 1 Cut D2500-3 to length: 84.25" A.M 05-12-29 Use Jig DT8094 to drill pilot holes. A.M 05-12-29 Open to 0.625 diameter using a uni-bit. A.M 012 29 ②			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 A.M 05-12-30 ②			
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/04
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: LG

Pmt 05-12-30 (2)

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Scn - 06/07/04

(2)

SP 06/01/04 (2)

Job Completion



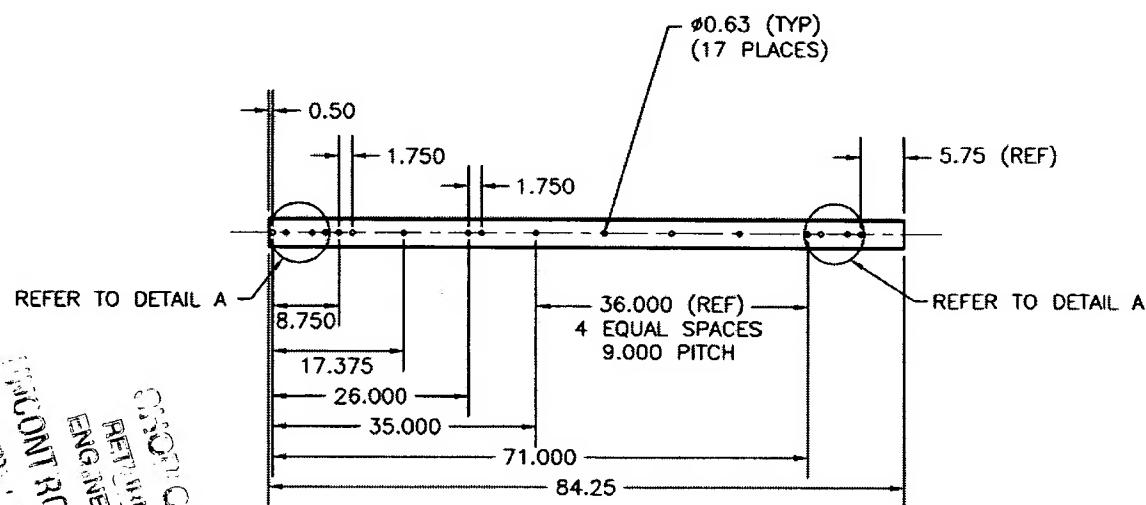
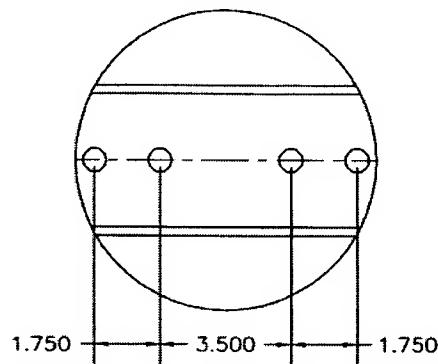
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		REV. D
		D2597
DATE		SHEET 1 OF 1
98.09.14		SCALE
A	96.09.16	1:24
B	96.10.29	NEW ISSUE
C	97.07.23	5.75 WAS 0.50
D	98.09.14	0.63 WAS 0.56
		INCORPORATED DEO 9097
		204 WEB